

Date: Monday, 20/04/2009 11:05:20 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HIGH AFT X-TUBE 412
Job Number	: 47283 ✓		
Estimate Number	: 10559	Part Number	: D412664203 ✓
P.O. Number	:	Drawing Number	: D412-664-243 REV D
This Issue	: 20/04/2009 S.O. No. :	Project Number	: N/A
Prsht Rev.	: NC	Drawing Revision	: D
First Issue	: / / Type : CROSSTUBES	Material	:
Previous Run	: 47156	Due Date	: 08/05/2009 Qty: 1 Um: Each
Written By	:		
Checked & Approved By	: <u>JLD 09.04.20</u>		
Comment	: Est Rev:E 04.02.16 Reformat; Added D3189-1 K/DS Est Rev:F 06-03-29 Remove Coments on Pick List JLM Est Rev:G 06.12.08 per ECN 886 EC Est Rev:H 07-04-30 As per Rev D JLM Est Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



*HJ for JLD 09/05/08*



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 006

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

3.0	D412664203TRN	Crosstube Turning Detail
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B-46933**MB**09-04-22**①*

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------

*MB**09-04-23**②*

Comment: BENDING MACHINE

Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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Comment: DIMENSIONAL CHECK OF X-TUBES

*pk*  
*①*  
*09.04.23*

**B47283**

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-664-203 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: A Date: 09/05/11

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>47283</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.04.23	4	Tube bent low on one side S 24.07	<p>GP</p> <p>09.04.23</p> <p>per</p> <p>09/04/23</p>	Acceptable	<p>[Signature]</p> <p>09-4-29</p>	<p>S</p> <p>09/04/07</p>	<p>GP</p> <p>09.04.23</p> <p>per</p> <p>09/04/23</p>	<p>S</p> <p>09/04/23</p>

NOTE: Date & initial all entries

Date: Monday, 20/04/2009 11:05:20 AM  
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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 47283

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-SCRIBE PART # & BATCH #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

RT  
09-04-27

AB  
09-04-27 0

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Am 9-4-27

(1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S 07/04/27 (4)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/04/27 (4)

10.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038 Or

Issue P/O: 8713 LPI as per ASTM 1417

Level 2 Attach copy of NDT results to work order

C 09/05/04 (1)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C 9/05/04 (1)

W/O:		WORK ORDER CHANGES					
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## Process Sheet

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Drawing Name: HIGH AFT X-TUBE 412

Job Number: 47283

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC5

INSPECT WORK TO CURRENT STEP



ml 09 05 04



①

Comment: Inspect for damage & ensure results are as per Dwg D412-664-203

13.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time:

7:00

Finish Time:

9:15

PAINT:

Start Time:

12:30

Finish Time:

2:00

IT 09-05-05

14.0

QC14

INSPECT SPRAY PAINT



ml 09 05 06



①

Comment: Inspect Spray Paint

Wrap in plastic bag to protect from scratches

15.0

D3595063570

RUBBER CUSHION



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Rubber Cushion

Batch: 42243

ml 09 05 07

16.0

D2856600

Abrasion Strip



Comment: Qty.: 1.7640 f(s)/Unit Total: 1.7640 f(s)

Pick:

Qty Part number Description

Batch

2 D2856-600(Cut to 10.090") Abrasion Strip

36398

ml 09 05 06

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 47283

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

D28961

Support



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2896-1

Support

43209

ml 09 05 07

18.0

D31891

Chafing Shield



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3189-1

Chafing Shield

43927

ml 09 05 06

19.0

MS2192028

Clamp(per MIL-DTL-8783C)



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-28

Clamp

109265

ml 09 05 06

20.0

MS2192030

clamp(per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

clamp(per MIL-DTL-8783C)

batch: 107600

ml 09 05 07

21.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Assemble as per Dwg D412-664-203

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 111249

Expiry Date: 02/2010

3-Install clamps as per Dwg D212-664-203 using installaiton jig DT9024 with 0.010 thick brass shims on both chafing sheild (D3189-1). Torque clamps to 80-100 in lb.

ml 09 05 08 (1)

ml 09-05-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47283

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-08 ①

23.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

24.0

AN640A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M111424

9/5/8

sq

25.0

AN641A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M109371

9/5/8

sq

26.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch: M11193

9/5/8

sq

27.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch: M110002

9/5/8

sq

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

2005-08 ①  
kit wrapped for E.D

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-664-203

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47283

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description :

\*\*\*\*\*Ensure tube is not packaged if curing time is less than 12 hrs, see step 27 for application time & date

\*\*\*\*\*

Time & date of packaging: 1.40

Location:

PPP Rev:

17

FINAL INSPECTION/W/O RELEASE

30.0

QC21



09/05/11 MF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-05-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

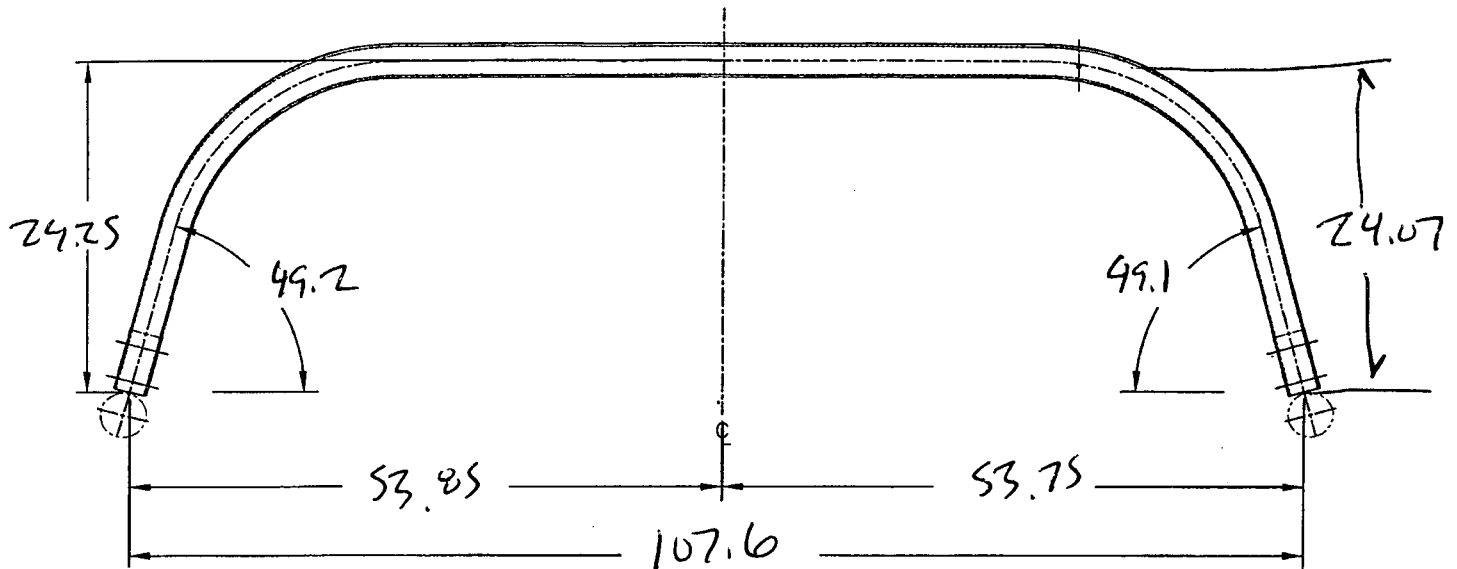
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	47283
Description: Crosstube High Aft (412)		Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1	

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



Comments
Tube bent low on one side. Acceptable. 09.04.23

QC15 Inspection	09.04.23
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>GP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D412-664-243	REV. D SHEET 1 OF 3
DATE 07.03.09		TITLE CROSSTUBE ASSEMBLY (412 HI AFT) NTS	
A	01.10.17	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30	
D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570	

RELEASE

07.04.24

Qty	Part Number	Description
X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
1	D6009-129	CROSSTUBE
2	D3595-063-570	RUBBER CUSHION
1	D2896-1	SUPPORT
2	D2856-600-1009	ABRASION STRIP
4	MS21920-28	CLAMP
2	MS21920-30	CLAMP (OR MS21920-32)
2	D3189-1	CHAFING SHIELD
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6009-129  
FINISHED LENGTH = 124.09±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.
- 13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY  
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SUBJECT TO AMENDMENT

WITHOUT NOTICE  
WORK ORDER

NO. 47283

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

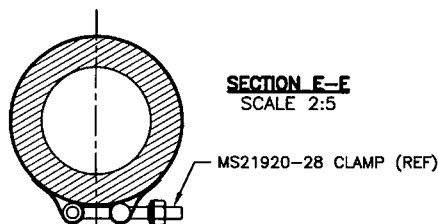
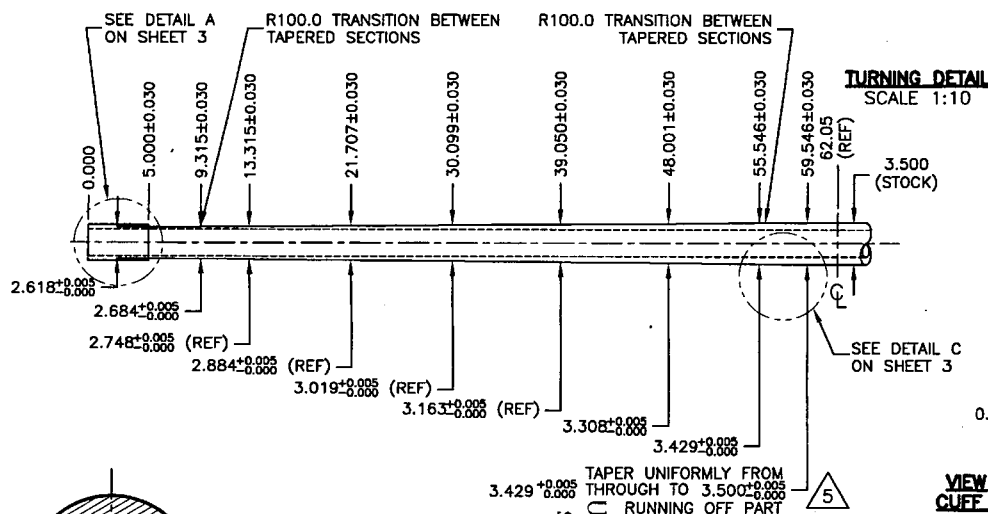
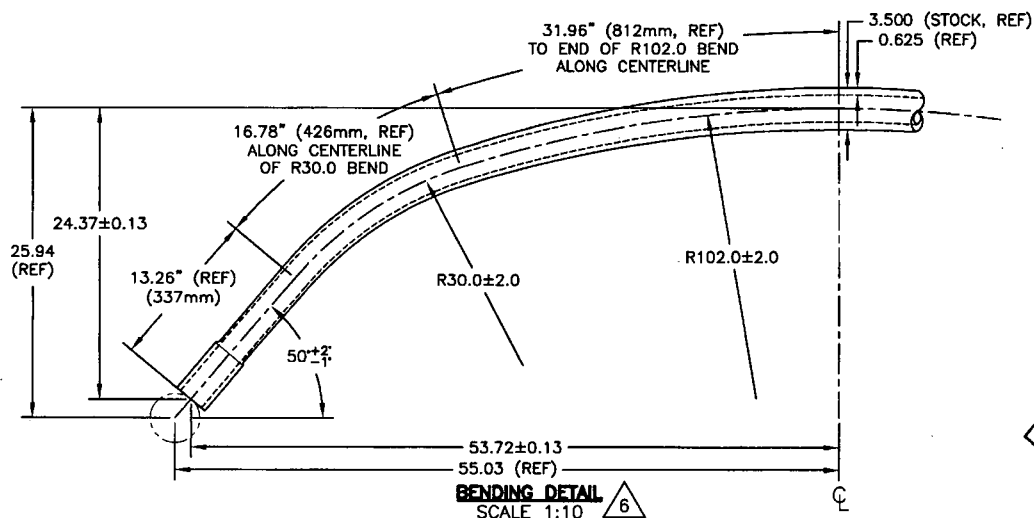
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

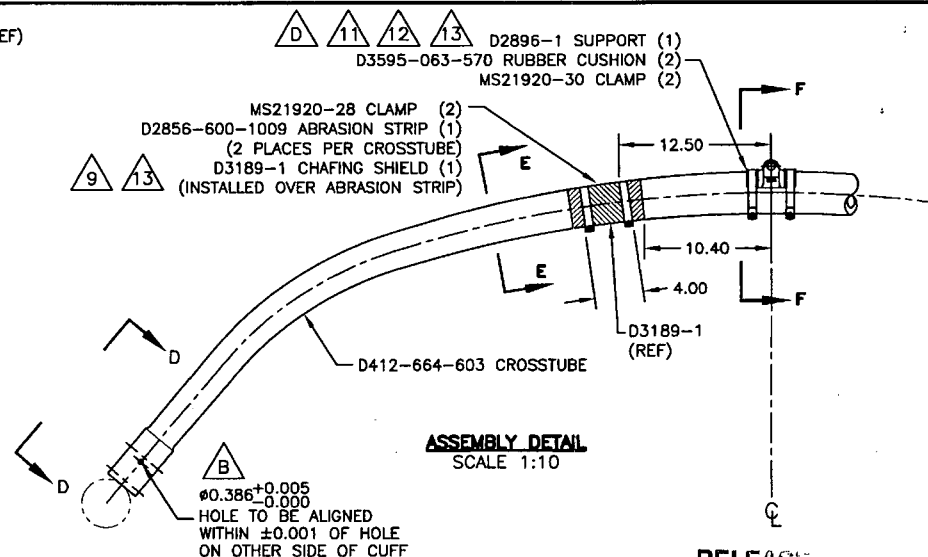
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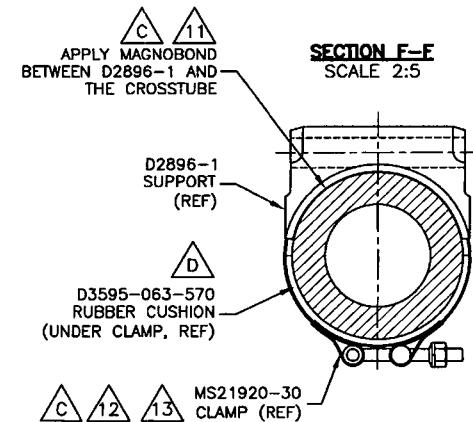
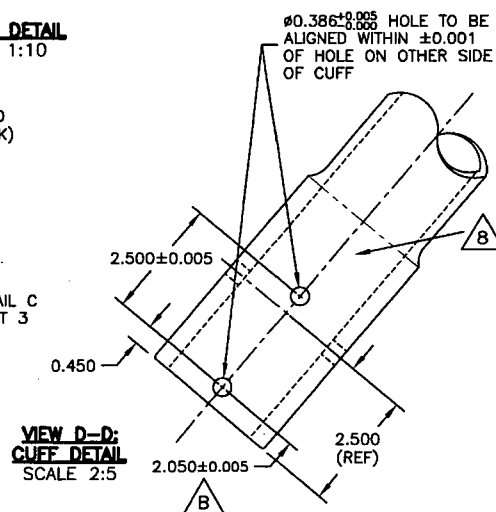




NO. 4183  
WORK ORDER  
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RELEASE  
07 04 24



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		PH	PH			
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		PH	PH	D412-664-243		SHEET 2 OF 3
		DATE		TITLE		SCALE
		07.03.09		CROSSTUBE ASSEMBLY (412 HI AFT)		1:10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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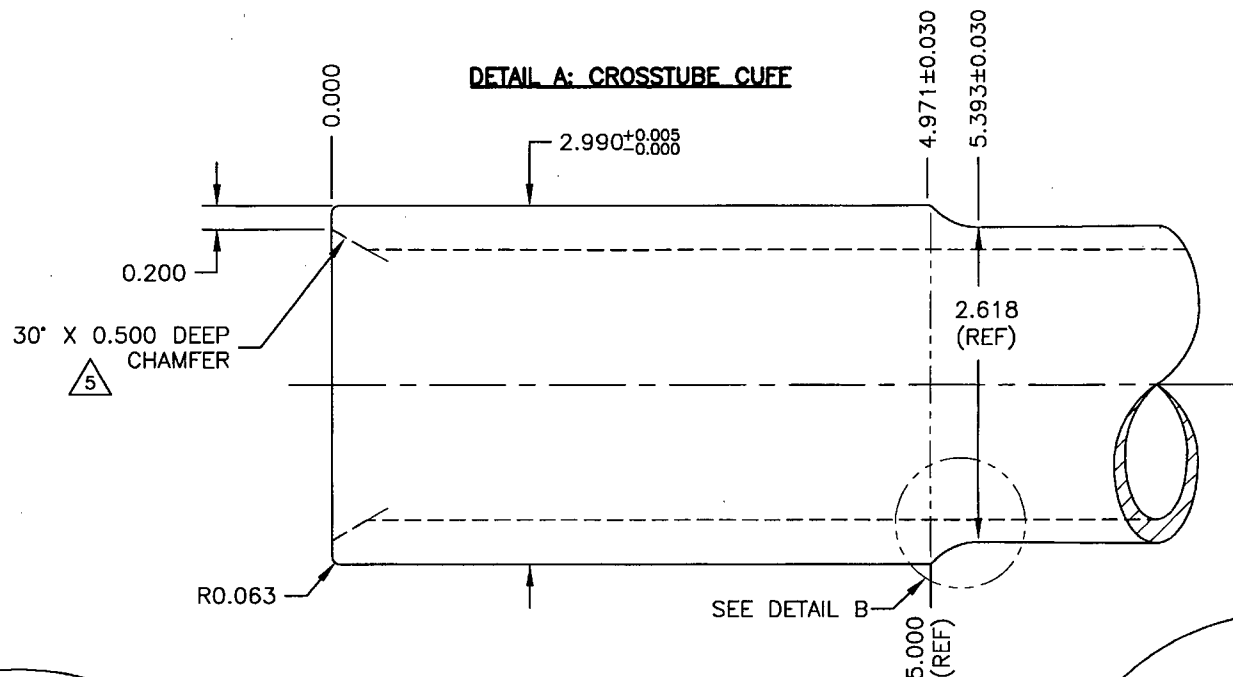
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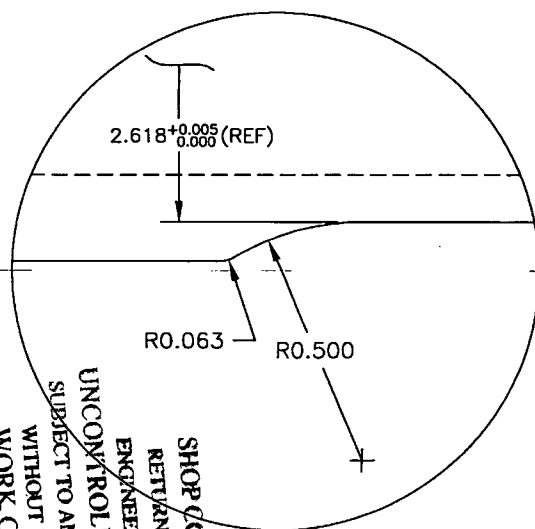
**NOTE:** Date & initial all entries

**RELEASED**  
07-06-244P  
REV ECN 009

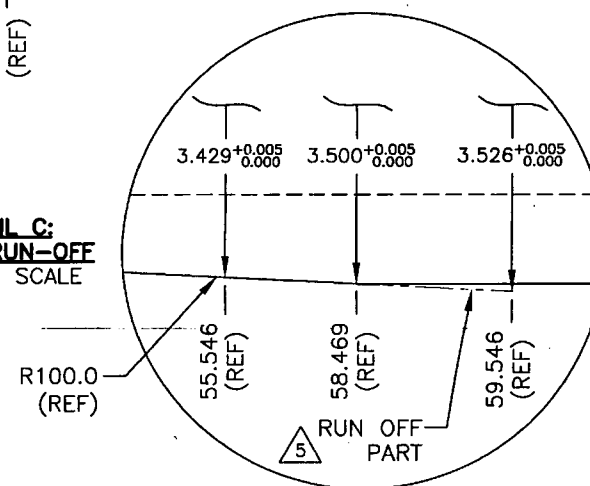
**DETAIL A: CROSSTUBE CUFF**



**DETAIL B: CUFF  
TRANSITION**  
SCALE 4:1



**DETAIL C:  
TAPER RUN-OFF**  
NOT TO SCALE



NO. 47283  
WORK ORDER  
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DESIGN PH	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. WILLOWDALE, ONTARIO, CANADA
CHECKED J	APPROVED [Signature]	DRAWING NO. D412-664-243	REV. D SHEET 3 OF 3
DATE 07.03.09	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	SCALE 1:1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# LIQUID PENETRANT TEST REPORT

P- 14938

CLIENT	<u>DART Aerospace</u>	DATE	<u>MAY 1-2007</u>	PAGE	<u>1</u>	OF	<u>1</u>
ATTENTION	<u>LINDA</u>	ACUREN JOB NO.	<u>100-09-001387</u>	TIME	AM <input checked="" type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	<u>1270 ABERDEEN</u>	PO/VO NO.	<u>8713</u>				
	<u>HAWKESBURY, ONT.</u>	WORK LOCATION	<u>PLANT</u>				
	<u>K64 1K7</u>	ACCEPTANCE STD.	<u>ASTM 1417</u>	REV./DATE	<u>2007</u>		
PROJECT	<u>F.P.I.</u>						
ITEM(S) EXAMINED	<u>MACHINED PARTS AND CROSS TUBES</u>						

JOB DESCRIPTION	PROCEDURE No. LT-XXXX REV./DATE	TECHNIQUE No. LT-XXXX-XXX REV./DATE
PART NO.		MATERIAL <u>STAINLESS</u> THICKNESS
SCOPE	<u>100% EXTERNAL</u>	<u>STEEL MACHINED PARTS</u>
	<u>EXAMINATION</u>	<u>AND ALUMINE ALUMINUM X-TUBES</u>

TEST DETAILS	
METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH <input type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND <u>MAGNAFLUX</u>	BLACK LIGHT S/N <u>IPES</u> <input checked="" type="checkbox"/> OUTPUT > 1000 $\mu$ W/cm <sup>2</sup> <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT <u>EL 67</u> MINIMUM DWELL TIME <u>45X</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER <u>H2O</u> MINIMUM DRY TIME <u>&gt;10</u> MIN.	OTHER <u>LABINO</u>
DEVELOPER <u>SKD 52</u> MINIMUM DWELL TIME <u>10</u> MIN.	LIGHT METER S/N
DEVELOPER TYPE <input checked="" type="checkbox"/> NON AQUEOUS <input type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	CAL DUE DATE <u>FEB 2010</u>

TEST SURFACE	
SURFACE CONDITION <input type="checkbox"/> AS GROUND <input type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input type="checkbox"/> CLEAN BARE METAL	
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F	

RESULTS- <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL																												
<table><tr><td>COMMENTS</td><td>ACCEPT</td><td>REJECT</td></tr><tr><td><u>Job # 46760 - 8 Pcs.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 46761 - 9 Pcs.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47284 - 1 Pc.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47283 - 1 Pc.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47155 - 1 Pc.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47156 - 1 Pc.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 47371 - 1 Pc.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr><tr><td><u># 46699 - 12 Pc.</u></td><td><input checked="" type="checkbox"/></td><td><input type="checkbox"/></td></tr></table>	COMMENTS	ACCEPT	REJECT	<u>Job # 46760 - 8 Pcs.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 46761 - 9 Pcs.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47284 - 1 Pc.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47283 - 1 Pc.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47155 - 1 Pc.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47156 - 1 Pc.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 47371 - 1 Pc.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u># 46699 - 12 Pc.</u>	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<u>mm 09 05 04</u>
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<u>ALL ITEMS EXAMINED WERE FOUND ACCEPTABLE</u>																												

**Scope of Services**  
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

**Standard of Care**  
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE <u>Jason Hurlbuck</u>	DTR # <u>E-27911</u>
TECHNICIAN (SIGNATURE): <u>[Signature]</u>	REPORT REVIEWED BY:
NAME (PRINT): <u>Mike Johnson</u>	NAME INITIALS
1 <sup>ST</sup> TECHNICIAN CGSB LEVEL <u>II</u> SNT LEVEL CGSB REG. No <u>6000</u>	2 <sup>ND</sup> TECHNICIAN CGSB LEVEL SNT LEVEL CGSB REG. No